

Work Order ID 135870

August 21, 2015 3:13:56 PM

135870

Order for Sept 4/15
Balance Stock.

Page 1

Item ID: D2362-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step Support Bracket

Stop *NS2*

Start Date: 8/21/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: SH Date: 20150821

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2362	Rev E1								

100

0.01

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.02

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E 2-Deburr
per dwg D2362

4 0 15-8-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 15-8-24

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

4 0 15-8-25
DAS
14
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐ _____							

August 21, 2015 3:13:56 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 8/21/2015 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 8/28/2015 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 4

Stop *NR2*

**Insp.
Stamp**

0.01

Quality Control

MCS AUG 27 2015

MCS AUG 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

August 21, 2015 3:14:01 PM

Page 1

Work Order ID: 135870

135870

Parent Item: D2362-3

D2362-3

Parent Item Name: Step Support Bracket

Start Date: 8/21/2015

Required Date: 8/28/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: G00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2397-3 *D2397-3* Rubber Cushion		Manufactured	No			100	Each	2.0000	1	4			
										FF	AUG 26 2015		

Location	Loc Qty	Loc Code
GA 135871	2	
133863	2	

2
2

D2265
D2265
Step Bracket

Manufactured No

160 Each 44.0000 1

4

FF

SL 15-8-24

Location	Loc Qty	Loc Code
ST361	30	
122090	30	
ST478a	14	
97950	14	

4

D2397-1
D2397-1
Rubber Cushion

Manufactured No

160 Each 2.0000 1

4

FF

AUG 26 2015

Location	Loc Qty	Loc Code
GA 135872	2	
133862	2	

2
2

DART



20150821 SK 135870

RELEASED
95.12.14 KE

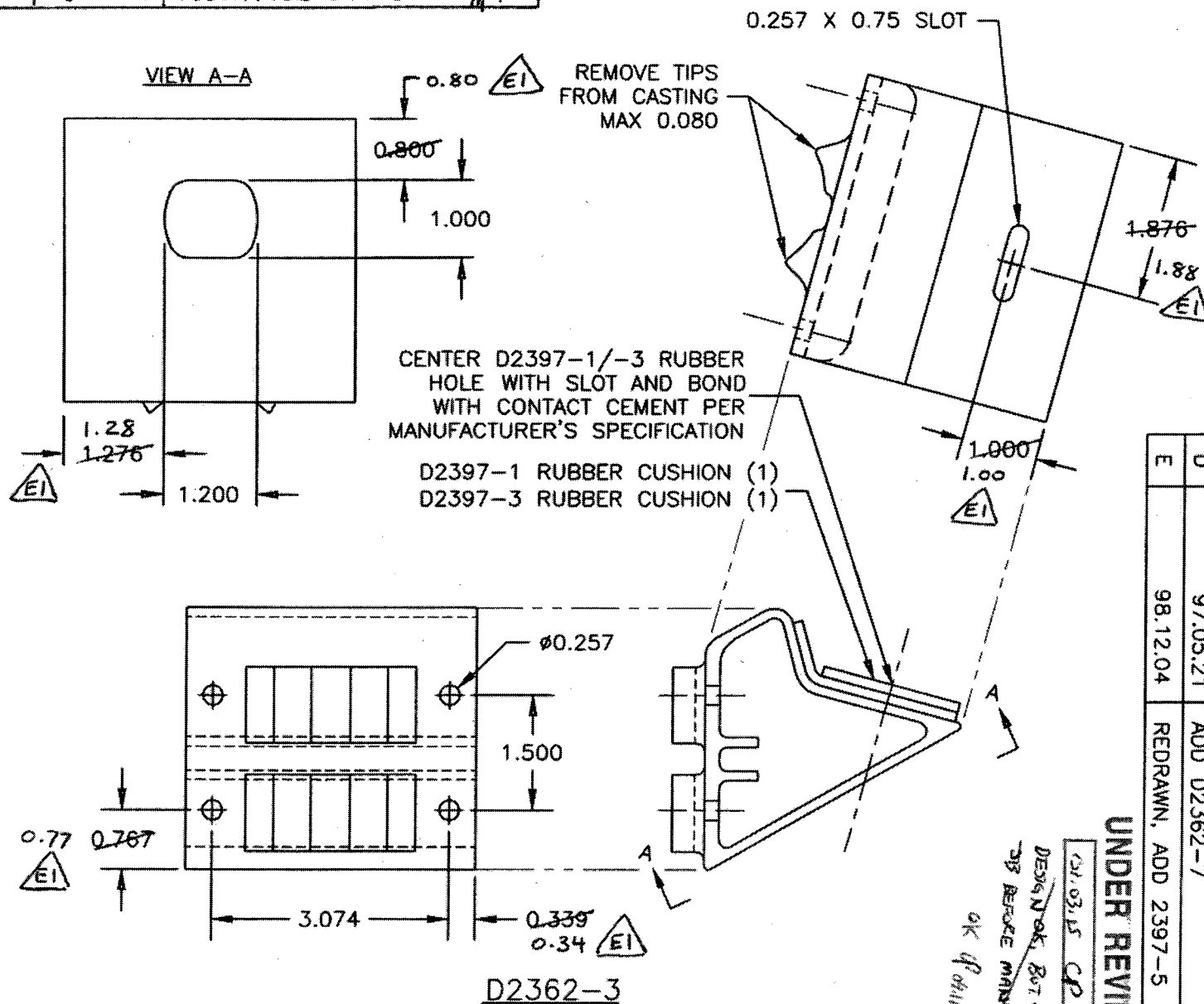
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
KE	CP	D2362	
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

12.03.15 CP

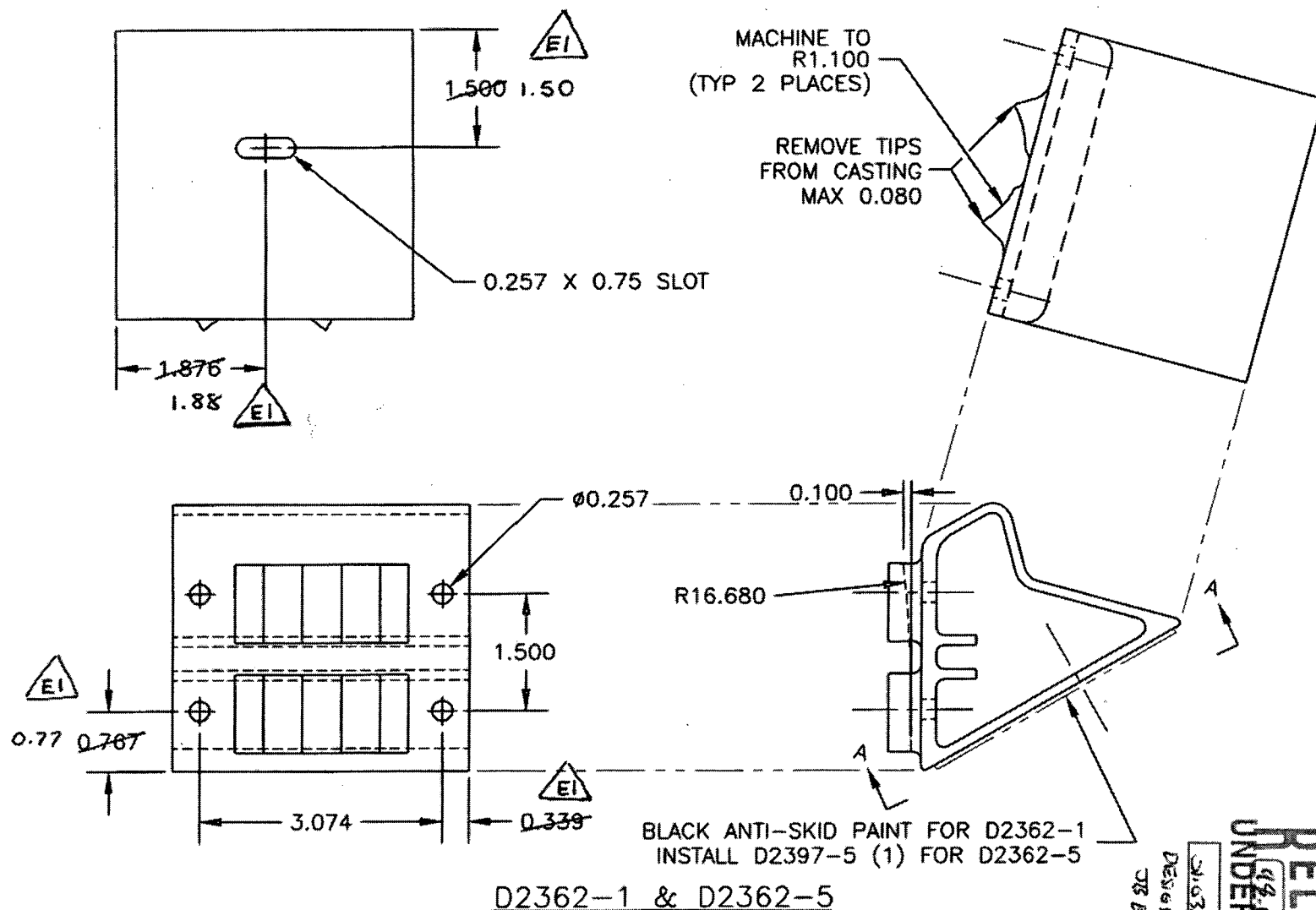
DESIGN OK BUT CHECK WITH
DIB BEFORE MANUFACTURE
OK 07/11/04

EI 03.10.07 TOLERANCE CHANGE ~~RT~~



NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

VIEW A-A



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 2 OF 3
		SCALE 1:2

RELEASED
98.12.14
UNDER REVIEW

DESIGNER, BUT CHECK BY
OR BEFORE MANUFACTURE

OK 10/1/09



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>KE</i>	<i>HA</i>	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3
		SCALE 1:2

UNDER REVIEW

01/03/15 CP

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

